

ABSTRACT

5 A blow mold assembly for an I.S. machine for
blowing a parison of glass and cooling the blown parison
into a formed bottle which can be removed from the blow
mold. A blow head is lowered onto a blow mold and final
air is applied. A predetermined time after the blow head
engages the top surface of the blow mold the blow head is
10 lifted a selected vertical distance above the top surface
of the blow mold to an exhaust position allowing cooling
air to escape from the blow mold. The selected vertical
distance is selected so that at least a minimum pressure
will continue within the formed bottle. The blow head is
15 maintain at the exhaust position for a predetermined time
and then retracted. The selected vertical distance and
the predetermined time can be set as desired.